

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023024**Date Inspected:** 28-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng /Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Scott Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 10 – Tower Shop

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 016 located on 25TR1-001. Welder is identified as 057266. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 043 located on BK014A1-001. Welder is identified as 053869. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

In Process Inspection SMAW

This QA Inspector observed the following work in progress: SMAW welding of weld joint 044 located on BK014A1-001. Welder is identified as 056364. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: SMAW welding of weld joint 044 located on BK014A1-001. Welder is identified as 044511. ZPMC Quality Control (QC) is identified as Qui Wen. The

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welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay 11 – Tower Shop

In Process Inspection SMAW

This QA Inspector observed the following work in progress: SMAW welding of weld joint 009 located on 32TR2. Welder is identified as 040611. ZPMC Quality Control (QC) is identified as Xu Le Feng.. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: SMAW welding of weld joint 009 located on 32TR2. Welder is identified as 040723. ZPMC Quality Control (QC) is identified as Xu Le Feng.. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: SMAW welding of weld joint 009 located on 34TR2. Welder is identified as 040614. ZPMC Quality Control (QC) is identified as Xu Le Feng.. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: SMAW welding of weld joint 009 located on 34TR2. Welder is identified as 044551. ZPMC Quality Control (QC) is identified as Xu Le Feng.. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Visual Inspection

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08653.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK010A1-001-043, 044

BK010A8-001-045, 046, 047, 048, 049, 050

BK010A7-001-204, 205, 206, 207, 208, 209

BK010A6-001-045, 046, 047, 048, 049, 050

BK010A8-001-104, 105, 106, 107, 108, 109

BK010A6-001-104, 105, 106, 107, 108, 109

BK010A7-001-121, 122, 123, 124, 130, 131

BK010A6-001-013, 014, 015, 016, 019, 020, 158, 023, 115, 116, 029, 030, 031, 032, 033, 034, 041, 042, 112, 118, 043, 102

BK010A8-001-053, 054, 055, 056, 059, 060, 022, 021, 115, 116, 029, 030, 031, 032, 033, 034, 041, 042, 117, 118, 043, 044

BK010A6-001-053, 054, 055, 056, 059, 060

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08655.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

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BK16B-001-001, 002, 004, 005, 021

BK16-001-013, 014, 016, 017, 021

BK16A-001-013, 014, 015, 016

Magnetic Particle Inspection (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08653.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK010A1-001-043, 044

BK010A8-001-045, 046, 047, 048, 049, 050

BK010A7-001-204, 205, 206, 207, 208, 209

BK010A6-001-045, 046, 047, 048, 049, 050

BK010A8-001-104, 105, 106, 107, 108, 109

BK010A6-001-104, 105, 106, 107, 108, 109

BK010A7-001-121, 122, 123, 124, 130, 131

BK010A6-001-013, 014, 015, 016, 019, 020, 158, 023, 115, 116, 029, 030, 031, 032, 033, 034, 041, 042, 112, 118, 043, 102

BK010A8-001-053, 054, 055, 056, 059, 060, 022, 021, 115, 116, 029, 030, 031, 032, 033, 034, 041, 042, 117, 118, 043, 044

BK010A6-001-053, 054, 055, 056, 059, 060

Ultrasonic Testing Inspection (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08655.

This QA inspector performed UT of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report for this date.

The members are identified as:

BK16B-001-001, 002, 004, 005, 021

BK16-001-013, 014, 016, 017, 021

BK16A-001-013, 014, 015, 016

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang at 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt, Scott

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer